

**\*105951\***

August-27-13 1:20:41 PM

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 27/08/2013    **Start Qty:** 2.00    **\*2\***

**Cust Item ID:**

**Required Date:** 30/08/2013      **Req'd Qty:** 2.00      **\*?\***

**Customer:**

**Reference:**

13.08.27


**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code *	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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<b>Draw Nbr</b>	<b>Revision Nbr</b>
D4902	Rev A 

120

0.00

**\*120\***

## FLOW WATER JET

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File  
D4902-1 BLANK

130

0.00

**\*130\***

## HAAS CNC VERTICAL MACHINING #1

HAAS 1

## Memo

0.00

## HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FB205 and Dwg D4903  
3-Debur  
PROGRAM REV: AA  
FOLIO REV: AA

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**Cust Item ID:**

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Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

encl 13/09/01

2

Q

OC

## Memo

0.00

## Quality Control

QC8- Inspect parts - second check

0.00

**\*150\***

13.09.10

2



QC

## Memo

0.00

## Quality Control

Identify as per dwg & Stock Location GA

0.00

**\*160\***

2

## Packaging

## Memo

0.00

## Packaging

8  
13/04/19

**Work Order ID 105951****\*105951\***

Page 3

August-27-13 1:20:41 PM

Item ID: D4902-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd Skipaw, LH  
Start Date: 27/08/2013 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 30/08/2013 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21 - Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

13/9/2013 MF 13-9-19

# Picklist Print

August-27-13 1:20:39 PM

Page 1

Work Order ID: 105951  
Parent Item: D4902-1  
Parent Item Name: Fwd Skipaw, LH

Start Date: 27/08/2013  
Start Qty: 2.00  
Required Date: 30/08/2013  
Required Qty: 2.00

Comments: IPP REV:A NEW ISSSUE 13-08-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	670.0003		27.010526			
UHMW 1" Black										28			

Jm 13-08-28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	670.0002895	
121278	11.0002895	
122575	47.6	
123229	53	
123704	63.8	
123949	6.96	
124382	197.12	
124758	17.52	
125137	273	

125137

8 7 6 5 4 3 2 1

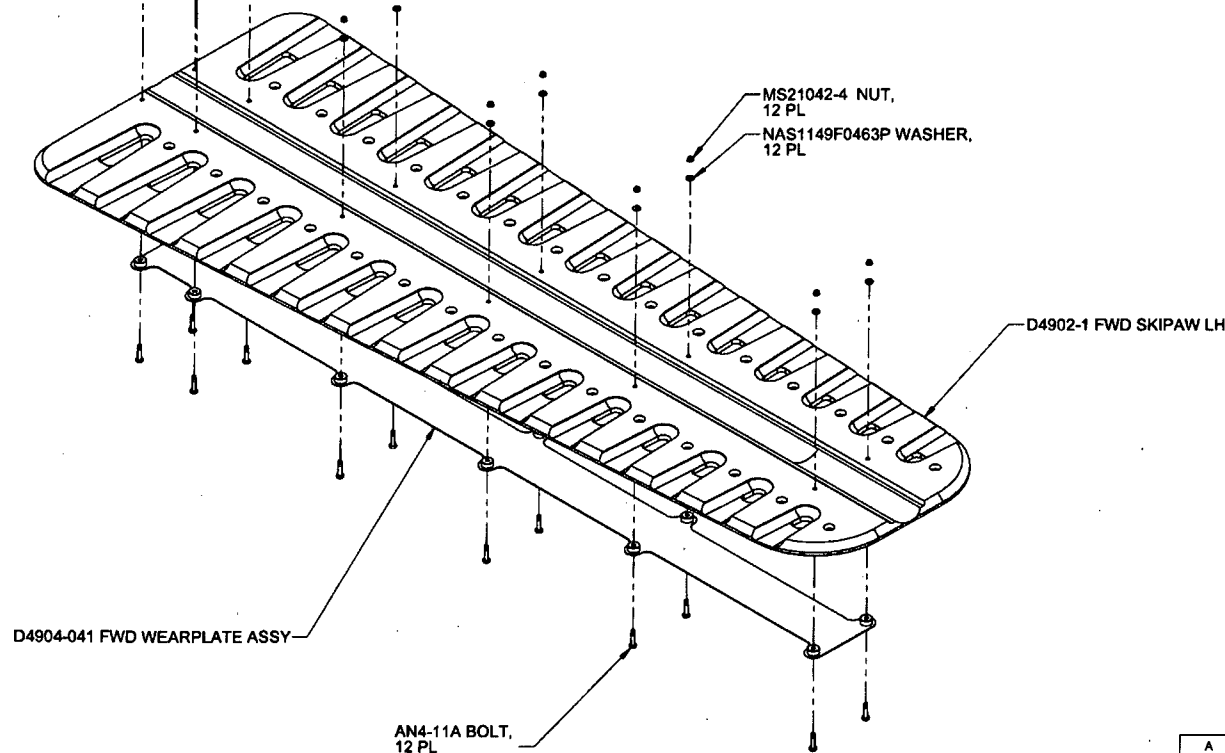
ITEM	QTY	P/N	DESCRIPTION
	X	D4902-041	FWD SKIPAW ASSY LH
1	1	D4902-1	FWD SKIPAW LH
2	1	D4904-041	FWD WEARPLATE ASSY
3	12	NAS1149F0463P	WASHER (AN980JD416)
4	12	MS21042-4	NUT
5	12	AN4-11A	BOLT

D

C

B

A

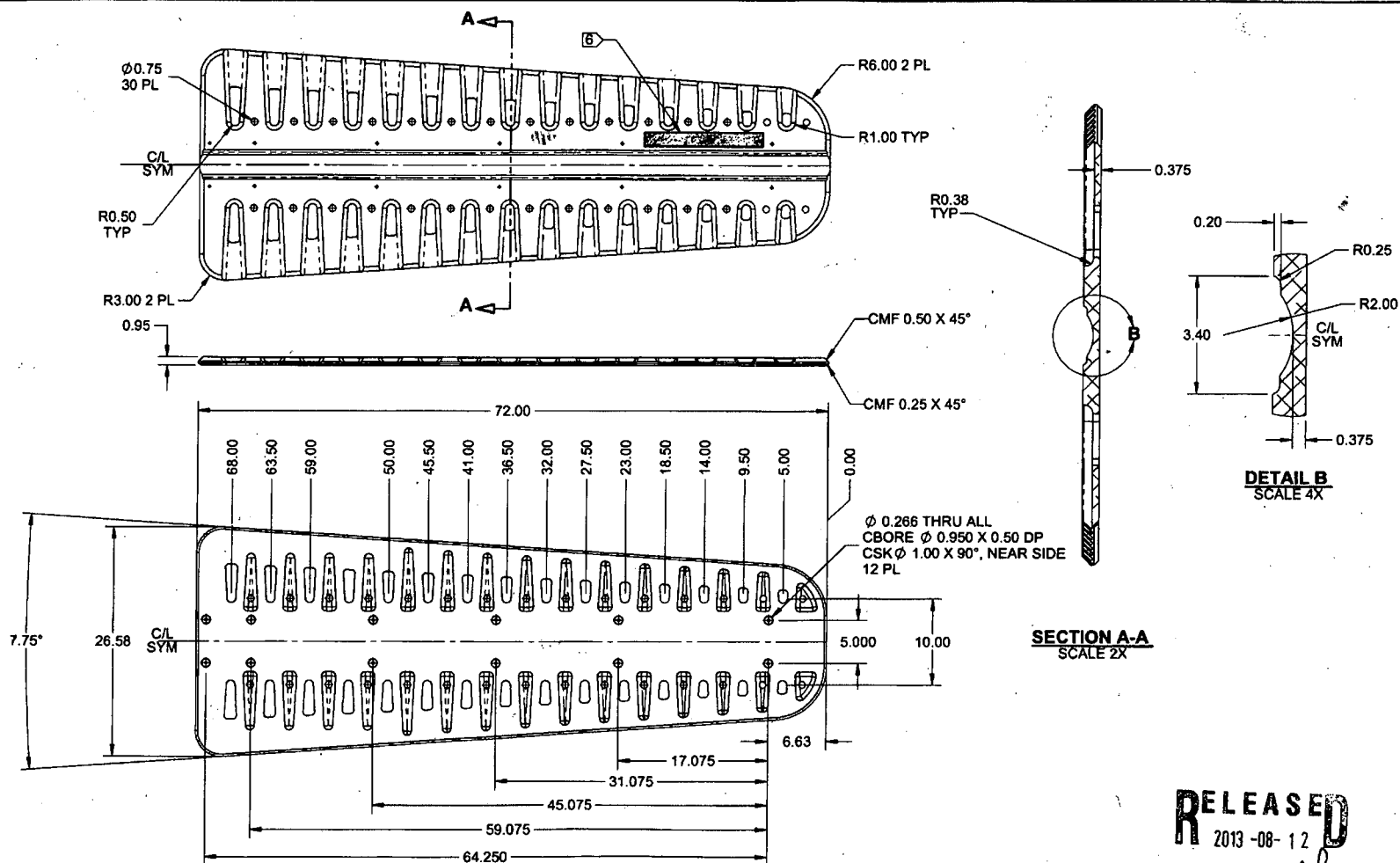


**D4902-041 FWD SKIPAW ASSY LH**

8 7 6 5 4 3 2 1

RELEASED  
2013-08-12

A	NEW RELEASE	DB	13.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	af	D4902	SHEET 1 OF 2
APPROVED	af	TITLE	SCALE
DE APPR.	#	FWD SKIPAW LH	NTS
DATE	13.07.22	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION A-A  
SCALE 2X

DETAIL B  
SCALE 4X

NOTES:

1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK  
REF DART SPEC MUHMWB100

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: ENGRAVE DART P/N "D4902-1" AND B/N USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010 PER QSI 044, METHOD 6.3

7) WEIGHT: 33.33 lbs

8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4902-1-A.IGES

D4902-1 FWD SKIPAW LH

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO. D4902	REV. A
MFG. APPR.	DB	TITLE FWD SKIPAW LH	SHEET 2 OF 2
APPROVED	DB	SCALE	NTS
DE APPR.	DB	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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RELEASED  
2013-08-12

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	105951
<b>Description:</b> FWD SKIPAW, 2 <sup>nd</sup>		<b>Part Number:</b>	D4902-1
<b>Inspection Dwg:</b> D4902 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.75	±.030	Ø.751	—		Vern	ML-06
R1.00	±.030	R1.00	—		"	
.95	±.030	.943	—		"	
.50 x 45°	±.030 X ± 1/2°	.470 x 45°	—		"	
.25 x 45°	±.030 X ± 1/2°	.220 x 45°	—		"	
72.00	±.030	72.000	—		M-type	ML-08
26.58	±.030	26.580	—		"	
64.250	±.005	64.250	—		"	
59.075	±.005	59.075	—		"	
45.075	±.005	45.075	—		"	
31.075	±.005	31.075	—		"	
17.075	±.005	17.075	—		"	
6.63	±.030	6.630	—		"	
5.000	±.005	5.000	—		Vern	ML-06
10.00	±.030	10.000	—		M-type	ML-08
5.00	±.030	5.000	—		"	
50.00	±.030	50.000	—		"	
R.38	±.030	R.380	—		R-G	
.375	±.010	.375	✓		Vern	ML-06
.20	±.030	.177	✓		"	
3.40	±.030	3.400	—		"	
R.25	±.030	R.250	—		R-G	
.375	±.030	.375	—		Vern	ML-06

<b>Measured by:</b> <i>mf</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 13/09/01	<b>Date:</b> 13.09.10	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15